

Date: Friday, 28/11/2008 3:10:36 PM
 User: Julie Dawson

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : TURNING DETAIL FOR D2892-1 |
| Job Number | : 43869 | | |
| Estimate Number | : 13233 | | |
| P.O. Number | : | Part Number | : DSK077 |
| This Issue | : 28/11/2008 S.O. No. : | Drawing Number | : DSK077 REV.A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : MACHINED PARTS | Drawing Revision | : A |
| Previous Run | : 43386 | Material | : |
| Written By | : | Due Date | : 05/12/2008 Qty: 10 Um: Each |
| Checked & Approved By | : <u>JUD 08.11.28</u> | | |
| Comment | : est rev A. 08.03.13 new issue EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------|--------------------|
| 1.0 | D6104003 | Round Billet, 17-4 |
|-----|----------|--------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Billet

Batch: 43919

JP 08/12/18

| | | |
|-----|------------|----------------------------|
| 2.0 | MORI SEIKI | MORI SEIKI CNC LATHE LARGE |
|-----|------------|----------------------------|



Comment: MORI SEIKI LATHE

Turn blank as per Folio FA082

JP 08/12/18

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JP 08/12/18

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

J.L 08/12/28

| | | |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock in Kanban

Location: CNC

JP 08/12/18

(10)

| | | |
|-----|------|------------------------------|
| 6.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|-----|------|------------------------------|



Comment: FINAL INSPECTION/W/O RELEASE

JP 08/10/05
MF 08-12-31

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

| | | |
|---|--------|---------------------|
| DART AEROSPACE LTD | | Work Order: 43869 |
| Description: Turning Detail for D2892-1 | | Part Number: DSK077 |
| Inspection Dwg: DSK077 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | 5 |
| Lathe Section | | | | | | | | |
| A | 2.524 | 2.529 | | 2.527 | 2.527 | 2.527 | 2.527 | 2.527 |
| B | 3.702 | 3.722 | | 3.712 | 3.712 | 3.712 | 3.712 | 3.712 |
| C | 2.814 | 2.834 | | 2.824 | 2.824 | 2.824 | 2.824 | 2.824 |
| D | 0.718 | 0.738 | | .728 | .728 | .728 | .728 | .728 |
| E | 0.090 | 0.110 | | .100 | .100 | .100 | .100 | .100 |
| F | 2.714 | 2.734 | | 2.724 | 2.724 | 2.724 | 2.724 | 2.724 |
| G | 2.029 | 2.049 | | 2.039 | 2.039 | 2.039 | 2.039 | 2.039 |
| H | 3.214 | 3.234 | | 3.224 | 3.224 | 3.224 | 3.224 | 3.224 |
| I | 0.913 | 0.933 | | .923 | .923 | .923 | .923 | .923 |
| J | 0.022 | 0.042 | | .032 | .032 | .032 | .032 | .032 |
| K | 0.090 | 0.110 | | .100 | .100 | .100 | .100 | .100 |
| L | | | | | | | | |
| M | | | | | | | | |
| N | | | | | | | | |
| O | | | | | | | | |
| P | | | | | | | | |

Measured by: *[Signature]* Date: 08/12/18

Audited by: *J.L.* Date: 08/12/18

Prototype Approval: Date:

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|---------------------------|--------------------|
| A | 08.04.22 | New Issue | KJ/JLM <i>[Signature]</i> | <i>[Signature]</i> |

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

| | | | |
|---|--------|--------------|--------|
| DART AEROSPACE LTD | | Work Order: | 43869 |
| Description: Turning Detail for D2892-1 | | Part Number: | DSK077 |
| Inspection Dwg: DSK077 | Rev: A | Page 1 of 1 | |

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | 5 |
| Lathe Section | | | | | | | | |
| A | 2.524 | 2.529 | | 2.527 | 2.527 | 2.527 | 2.527 | 2.527 |
| B | 3.702 | 3.722 | | 3.712 | 3.712 | 3.712 | 3.712 | 3.712 |
| C | 2.814 | 2.834 | | 2.824 | 2.824 | 2.824 | 2.824 | 2.824 |
| D | 0.718 | 0.738 | | .728 | .728 | .728 | .728 | .728 |
| E | 0.090 | 0.110 | | .100 | .100 | .100 | .100 | .100 |
| F | 2.714 | 2.734 | | 2.724 | 2.724 | 2.724 | 2.724 | 2.724 |
| G | 2.029 | 2.049 | | 2.039 | 2.039 | 2.039 | 2.039 | 2.039 |
| H | 3.214 | 3.234 | | 3.224 | 3.224 | 3.224 | 3.224 | 3.224 |
| I | 0.913 | 0.933 | | .923 | .923 | .923 | .923 | .923 |
| J | 0.022 | 0.042 | | .032 | .032 | .032 | .032 | .032 |
| K | 0.090 | 0.110 | | .100 | .100 | .100 | .100 | .100 |
| L | | | | | | | | |
| M | | | | | | | | |
| N | | | | | | | | |
| O | | | | | | | | |
| P | | | | | | | | |

| | | | |
|---------------------|-----------------------------|-------|----------|
| Measured by: | <i>[Signature]</i> 08/12/18 | Date: | |
| Audited by: | J.L | Date: | 08/12/28 |
| Prototype Approval: | | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|---------------------------|--------------------|
| A | 08.04.22 | New Issue | KJ/JLM <i>[Signature]</i> | <i>[Signature]</i> |

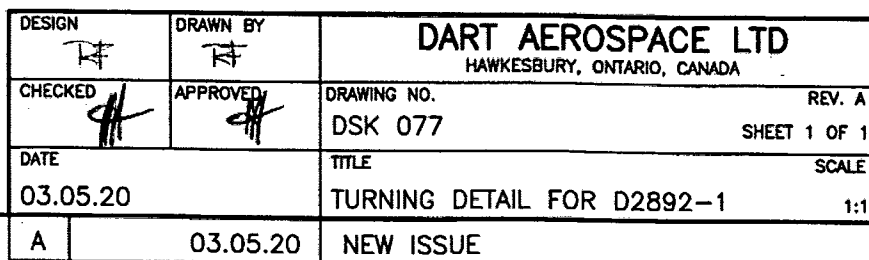
| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

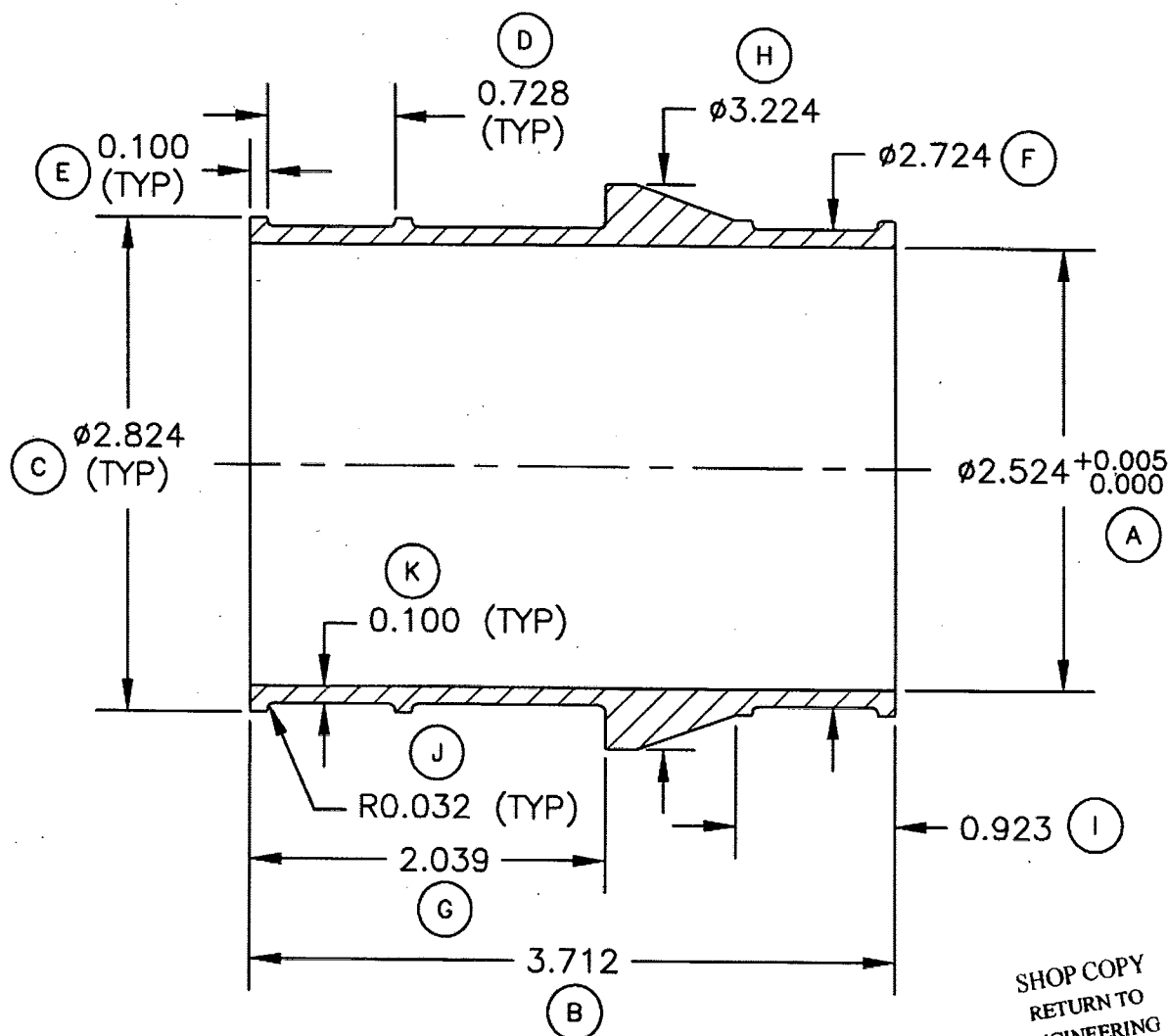
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



RELEASED
03.07.01



D2892-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43869

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| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries